

Work Order ID 76165

76165

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Monday, November 07, 2011 12:58:01 PM

Item ID: D3258-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle Bracket
 Start Date: 11/7/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: P Date: 11-11-07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3258	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3258 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-								
304 .063	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B11-1-7

(2)

B11-1-7

counts
(X2)

Sululob

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					21			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form as per Dwg D3258								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: SF 44								
Packaging	Memo	0.00							
Packaging									

SB 11/11/10

8 11/11/10

Counters
 (21)

SP 11-11-10

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76165

Monday, November 07, 2011 12:58:01 PM

N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

160

QC

Memo

0.00

Quality Control

mf
61-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 76165

76165

Parent Item: D3258-1

D3258-1

Parent Item Name: Angle Bracket

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.11.01 Added Steps 6-7KJ/JLM
IPP Rev:C Now on Waterjet 06-12-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

110

sf

131.3000

0.005

0.031579

.5

M304S16GA

B11-10-7

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

131.3

119346

131.3

119346

(21)

W/O:		WORK ORDER CHANGES					
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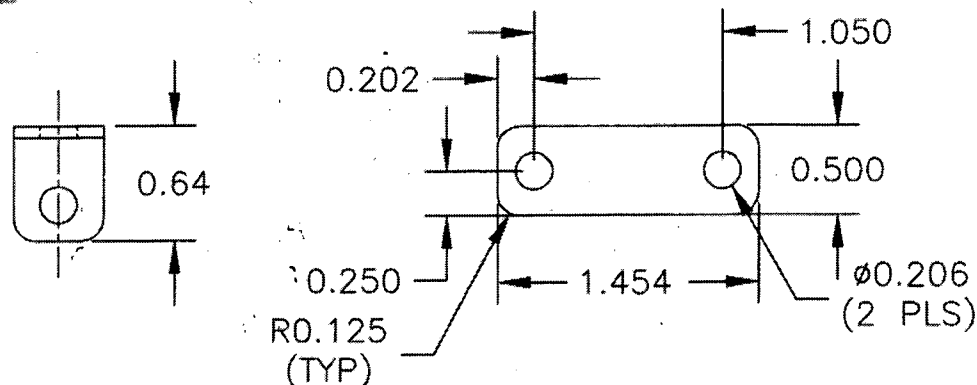
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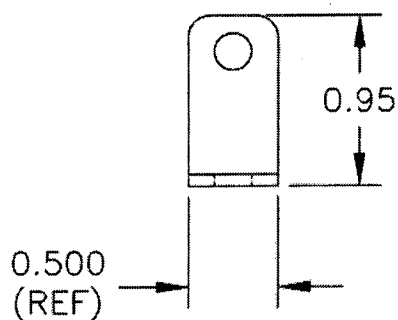


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3258	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE ANGLE BRACKET	SCALE 1:1
A	04.01.27	NEW ISSUE	

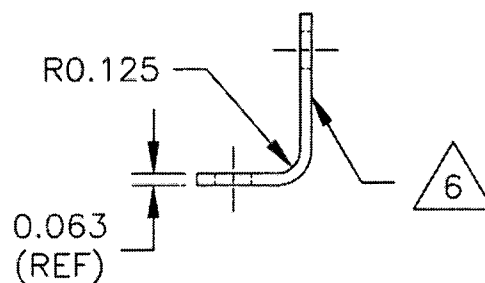
RELEASED
04.04.05



D3258-1 FLAT PATTERN



D3258-1 ANGLE BRACKET



SHOWN
REF.
ENGINEER
UNCONTROLLED
SUBJECT TO
WITH
WORK
NO. 74165

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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